

Fig. 1

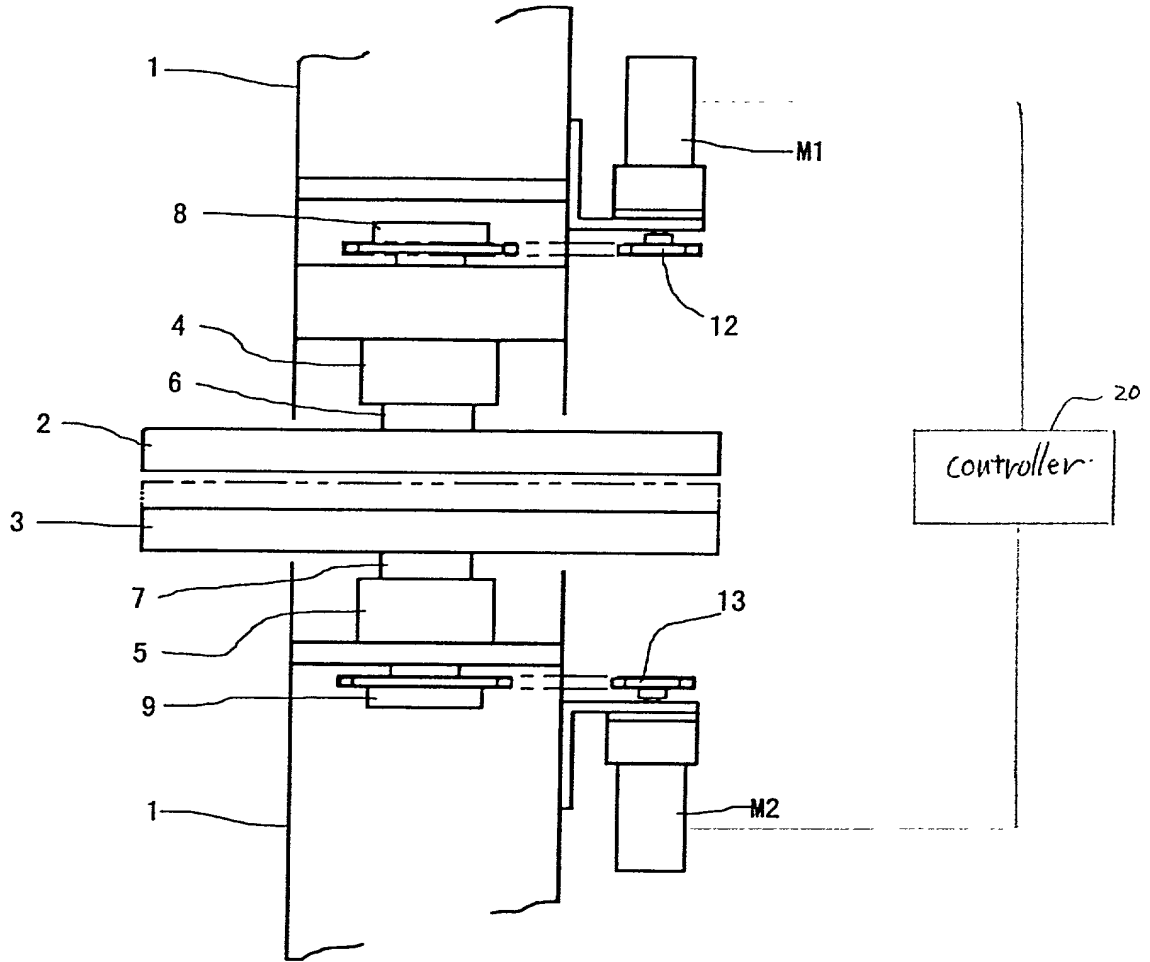


Fig. 2A

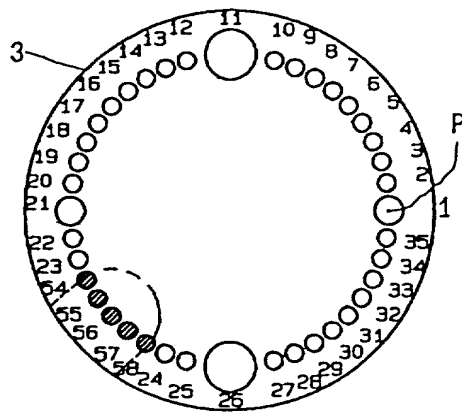
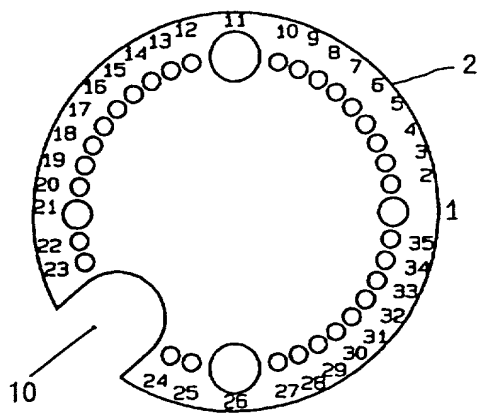


Fig. 2B

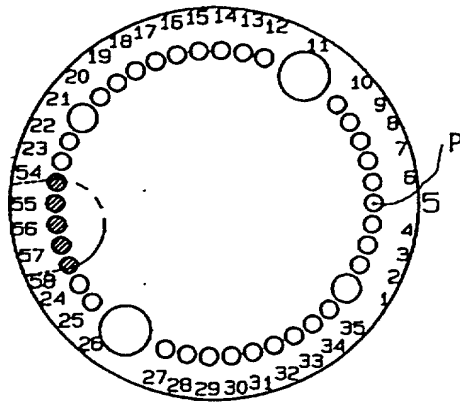
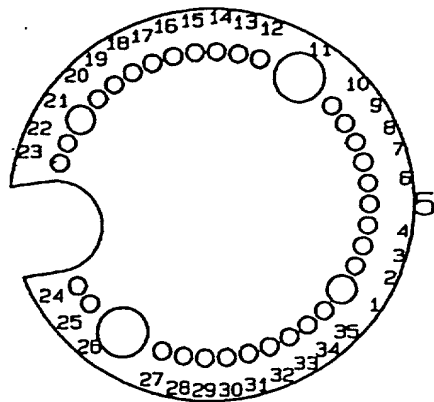


Fig. 2C

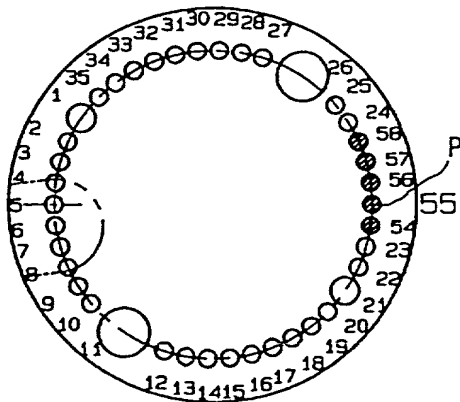
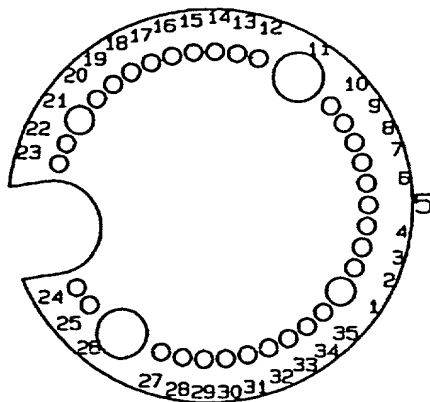


Fig. 3

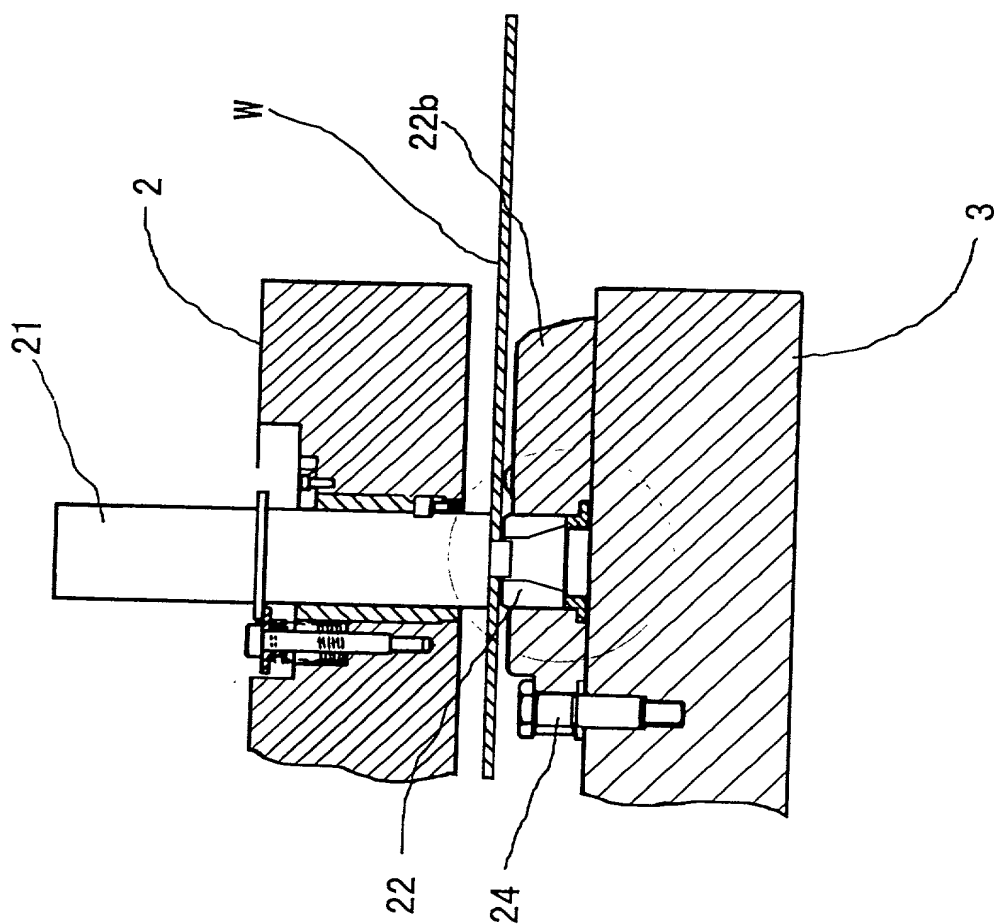
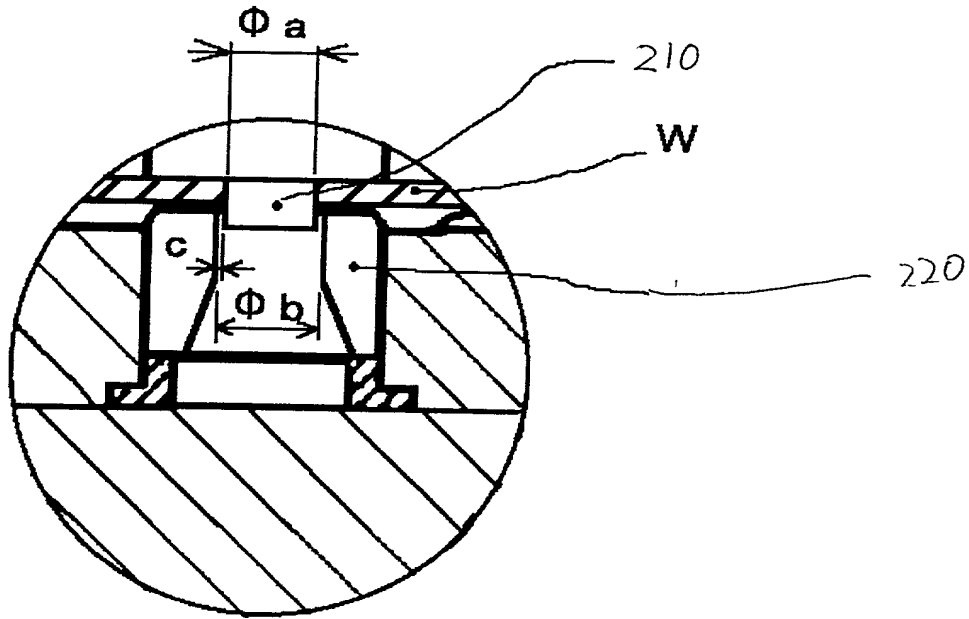


Fig. 4



- Φa : Diameter of blade of upper mold 210
 Φb : Diameter of hole of lower mold 220
 c : $(\Phi b - \Phi a) / 2$ (Clearance.)

Fig. 5.

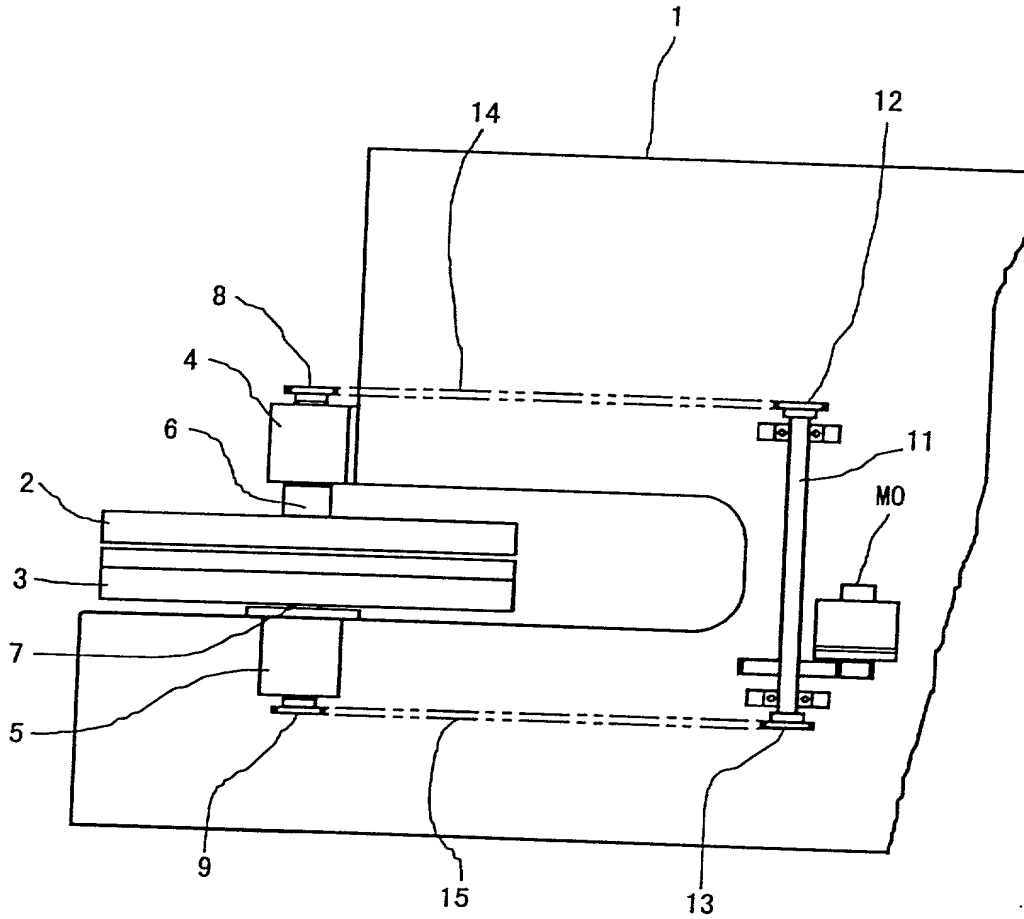
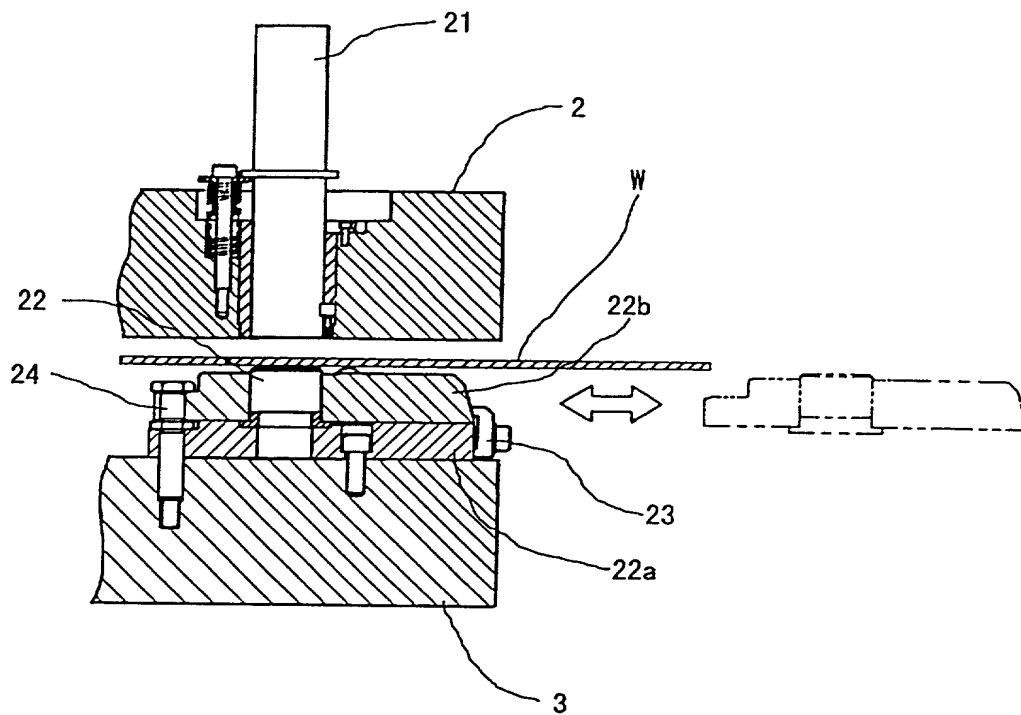


Fig. 6



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